

Date: Wednesday, 9/27/2006 11:09:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 28738D		Part Number	: D30657		
Estimate Number	: 10380		Drawing Number	: D3065 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/27/2006		S.O. No.	: N/A		
Prsht Rev.	: NC		Drawing Revision	: B		
First Issue	: 9/27/2006		Type	: SMALL /MED FAB		
Previous Run	: 27590D		Material	: N/A		
Written By	: <u>JK</u>		Due Date	: 10/10/2006		
Checked & Approved By	: <u>JK</u> 06 09.27		Qty:	60	Um:	Each
Comment	: Est:C 02/11/01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 0.1653 sf(s)/Unit Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M15295</u> <u>JK 06 09 27</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3065 Dwg Rev: <u>B</u> <u>JK 06 09 28</u> <u>61</u> Prog Rev: <u>B</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JK 06 09 28</u> <u>61</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>Jcb 06 09 02</u> <u>61</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>MF. 06/10/02</u> <u>61</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/11/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/27/2006 11:09:54 AM
User: Kim Johnston

Process Sheet

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Drawing Name: STEP SPACER

Job Number: 28738D

Part Number: D30657

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D30657

SB

06/11/14

61

MF

06/10/12

61

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YFC 06/11/15 X 61

9.0 QC3 INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

MF

06-11-18

61

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

MF

06-11-18

61

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 06/11/20

61

Job Completion



U 06/11/20

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28738 D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

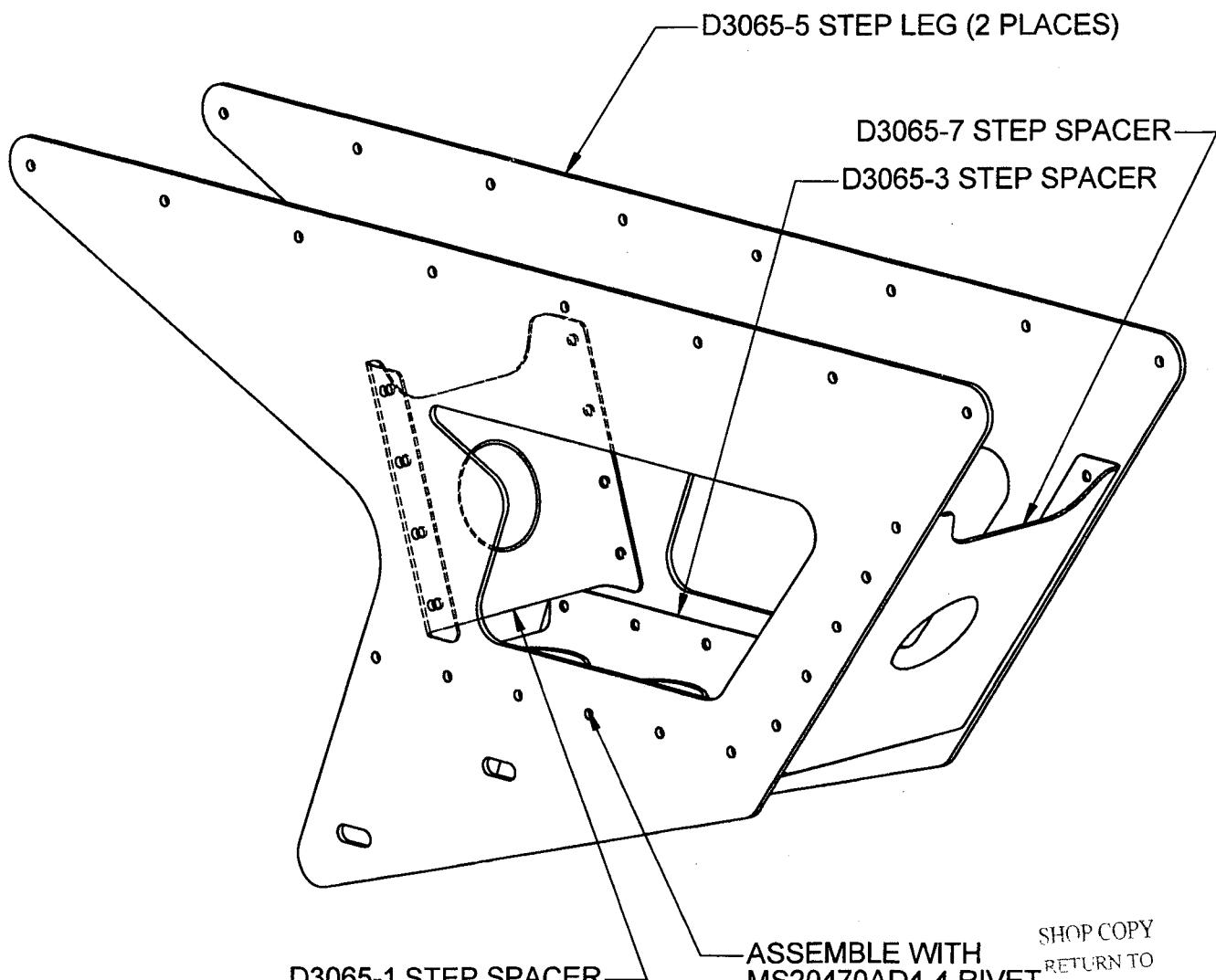
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/09/28	Date:	01/09/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE	1:2
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

RELEASED*06.06.20 PH***D3065-041 STEP LEG ASSEMBLY**

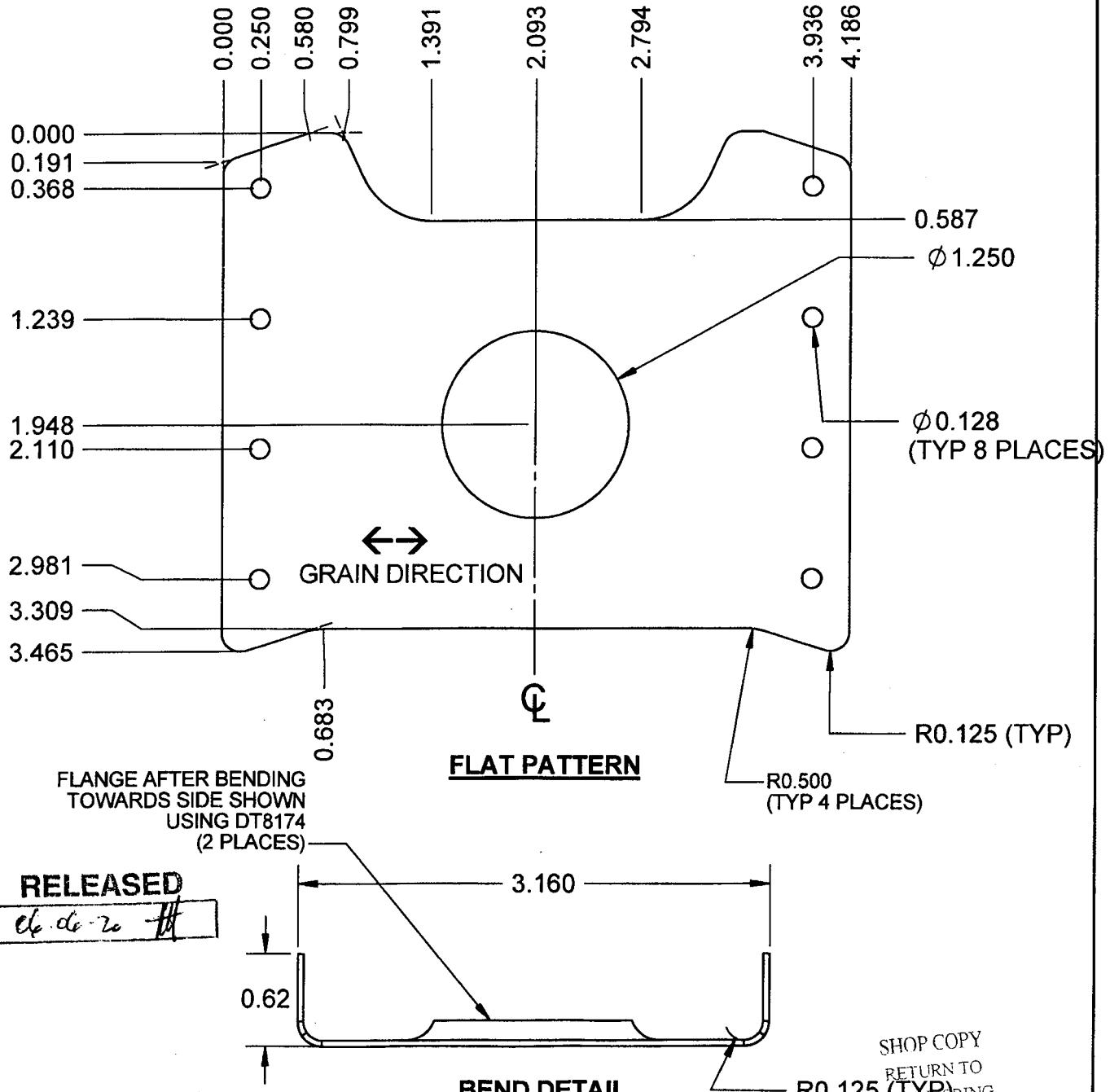
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CHECKED <i>PH</i>	APPROVED <i>AA</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

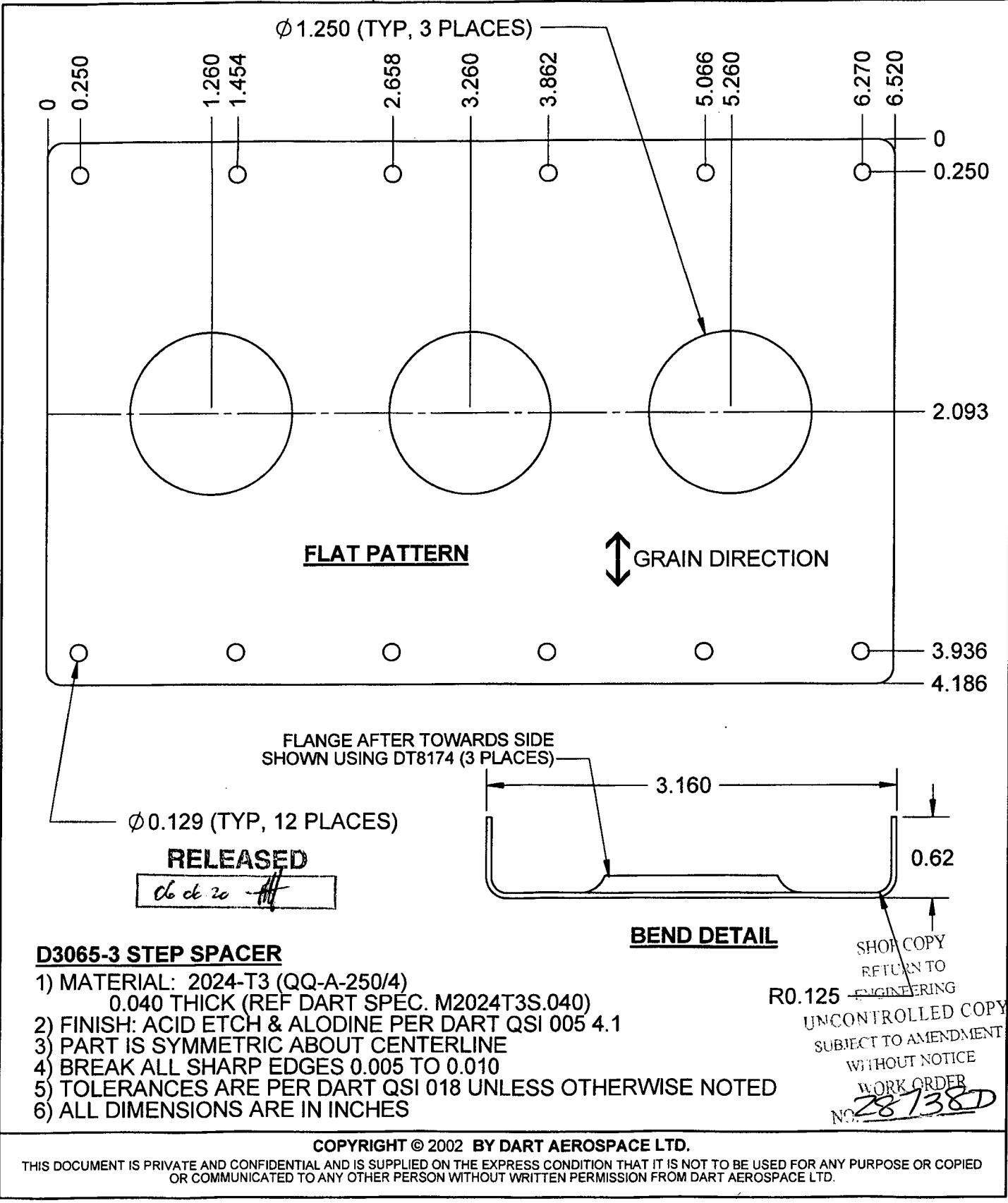
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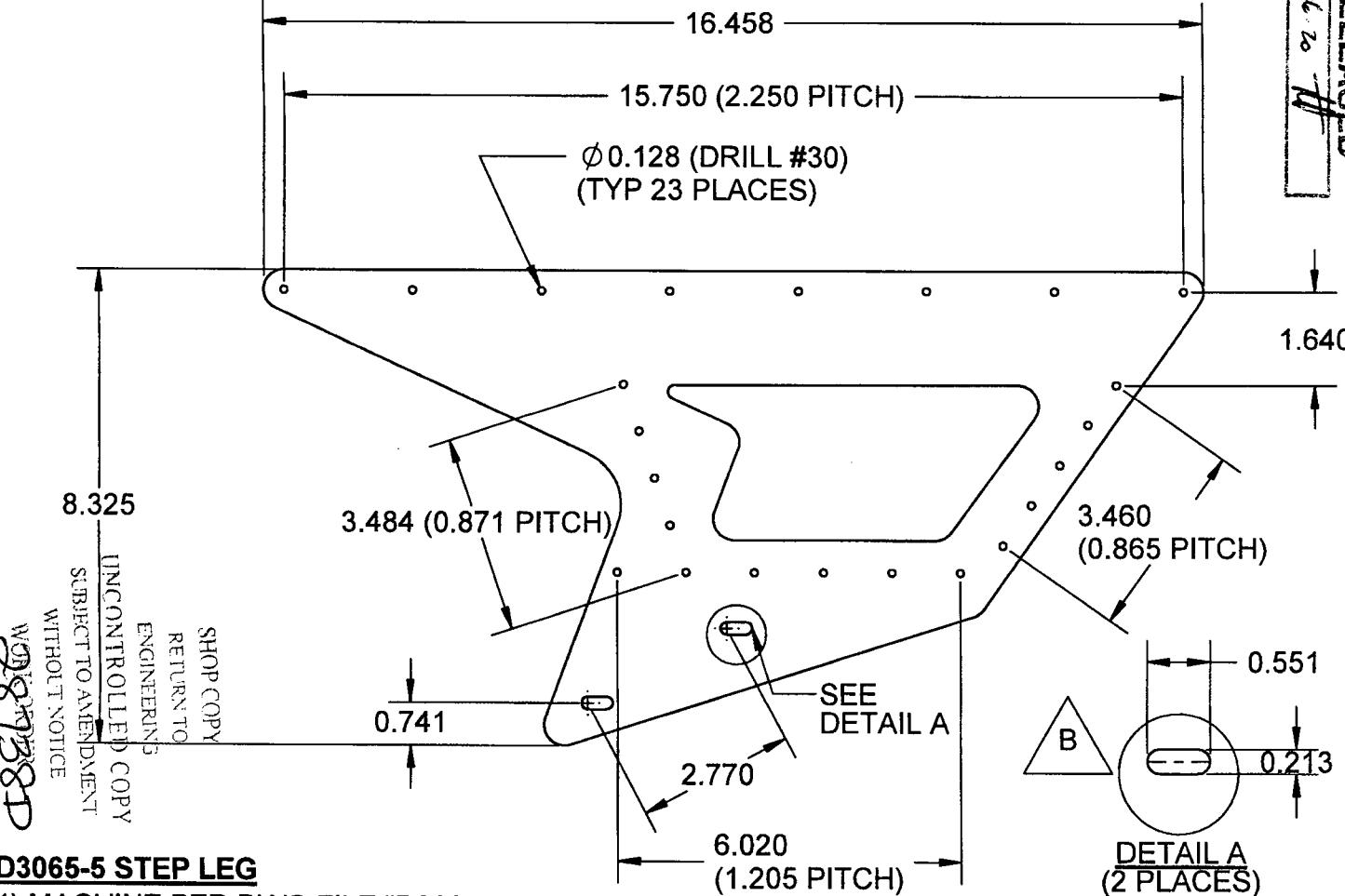
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	C.B	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	JK	D3065
DATE	06.05.23	STEP LEG ASSEMBLY
		SHEET 4 OF 5
		SCALE 1:3

RELEASED
06.06.23

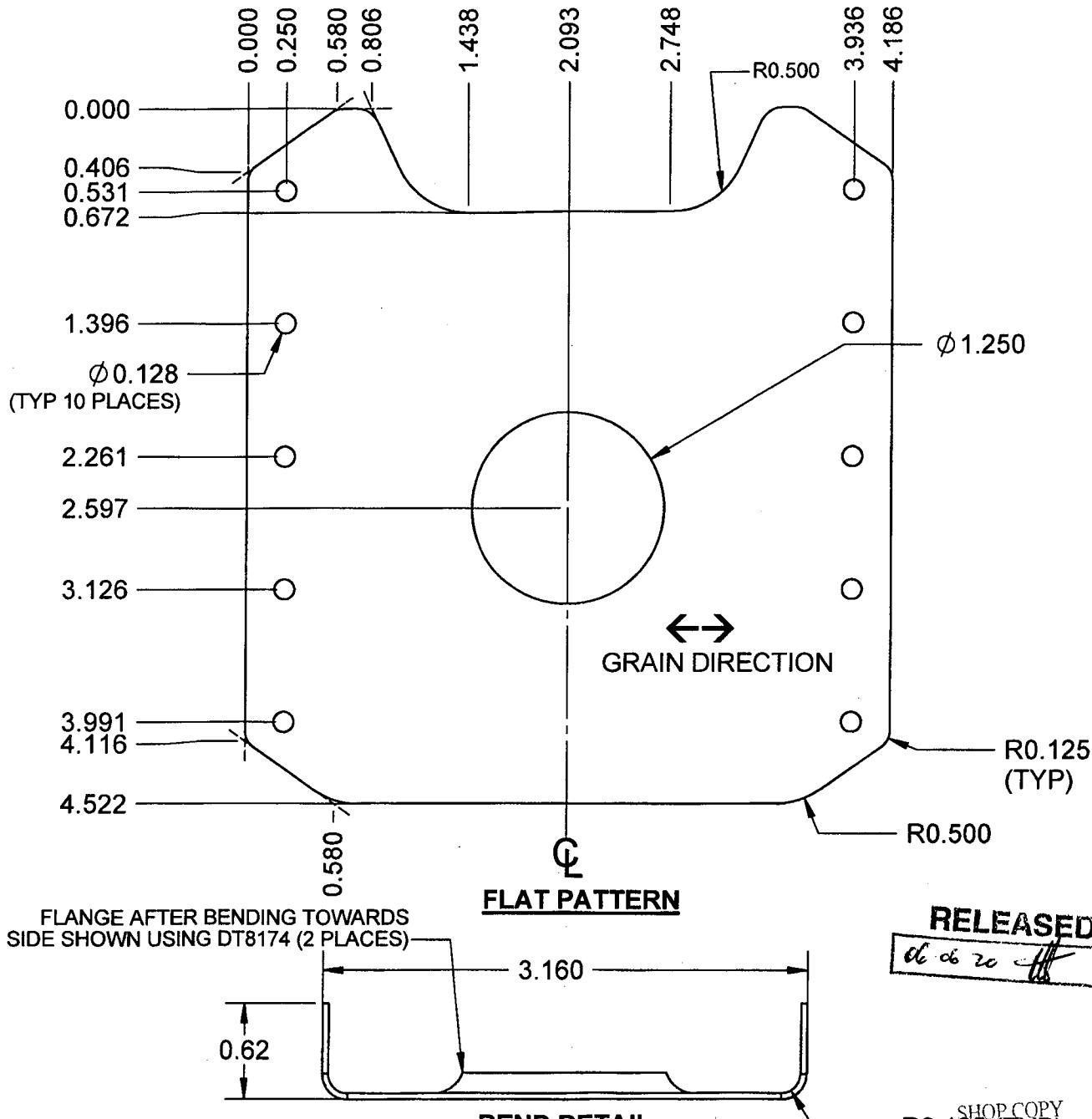


D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>PH</i>	<i>CB</i>	D3065	SHEET 5 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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